

**GENERAL INFORMATION**
**General information**

Typology	Ready to use silver
Color	Silver
Production process	Casting
Grain refinement level	High
Deoxidation level	Medium

**Commercial composition (%)**

AG	93.0
CU	4.0
ZN	3.0

**Melting Temperatures**

Solidus [°C]	790.0
Liquidus [°C]	890.0
Melting range [°C]	100.0

**FULL CHARACTERIZATION DATA**
**Color coordinates**

L *	a*	b*	c*	Yellow Index
95.5	-0.2	3.7	3.7	6.7

**Mechanical characteristics**

As cast hardness [HV 0.2]	55.0
Hardness after 70% area red. [HV 0.2]	165.0
Hardness after annealing [HV 0.2]	60.0
Double step age-hardening hardness [HV 0.2]	120.0
Single step age-hardening hardness [HV 0.2]	90.0
Tensile strength (Rm) [Mpa]	255.0
Yield strength (Rp0.2) [MPa]	100.0
Elongation at rupture (A) [%]	33.0

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	10.3
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**General characteristics**

As cast grain size [μm]	270.0
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**Product applications**

Stone-in-place casting  
Casting in closed systems  
Casting without stones

**CASTING PROCESSING PARAMETERS**

POURING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	560	600	990	1020
0.5 - 1.2 mm	520	560	970	990
> 1.2 mm	480	520	950	970

**Trees without stones**

Let the flask cool down in the chamber for 1 minute after pouring. Take the flask out of the machine without shaking it, let it cool for 15 minutes in air, then quench in water.

**Stone-in-place casting trees**

Let the flask cool down for 30-45 minutes, then quench it in water.

**Pickling**

Dip in RADIAL solution (50 g/l conc. at 60°C) for 2 minutes, or in sulphuric acid (10% concentration at 50°C) for 5 minutes.

**AGE HARDENING PROCESSING PARAMETERS**

SINGLE STEP	Temperature [°C]	Time [min]	Quenching
Age-hardening	300.0	90.0	In air or in furnace

DOUBLE STEP	Temperature [°C]	Time [min]	Quenching
Homogenization	730.0	40.0	In water, immediate
Age-hardening	300.0	60.0	In air or in furnace